Monday, 11/08/2008 1:52:38 PM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 41113

: 11/08/2008

Estimate Number

: 10329

P.O. Number

This Issue

Prsht Rev. : NC

First Issue Previous Run

: // : 40725 Type

S.O. No. :

: MACHINED PARTS

Part Number

Drawing Name

: D2743

Drawing Number

D2743 REV B

: CROSSBOLT SPACER

Project • Number **Drawing Revision** : N/A : B

Material

Due Date

: 15/08/2008

Each

Written By

Checked & Approved By Comment

Reformat; removed tumble and deburr step KJ/J

Additional Product

Job Number:



Seq. #:

Description:

1.0

M6061T6T0625W065

6061-T6 RD Tube .625 x.065W



Comment: Qty.:

0.2800 f(s)/Unit Total: 56.0070 f(s)

Material: 6061-T6 (WW-T-700/6)

Ø0.625 " x 0.065" wall

(M6061T6T0.625W.065) Batch: (10)

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA202 & DWG D2743

2-DEBURR AS REQUIRED

3.0

QC2



4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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D - 4 M -					_					

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	_
			QA: N/C	Closed:	Date:	

NCR:			WORK ORDE	ER NON-CONFORMANC	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification	Annewal	Annewal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
" 								

NOTE: Date & initial all entries

Date:

Monday, 11/08/2008 1:52:38 PM

User: '

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 41113

Part Number: D2743

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 06.08.15

Dart Aerospace Ltd

W/O;		WORK ORDER CH	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				•					
	<u></u>				<u> </u>				
Dart No		DAD # Equit Cotogony	NCD: Voc	No DO	۸.	Data			

Part No:	PAR #:	Fault Category:	NCF	R: Yes	No	DQA:	Date:
				QA: N	I/C C	losed:	Date:
NCR:	WO	RK ORDER NON-CO	NFORMANCE	(NCF	₹)		

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
							:	
		•						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: ムル13
Description: Cross Bolt Spacer	Part Number: D2743
Inspection Dwg: D2743 Rev: B	Page 1 of 1

Inspection Dwg	g: D2743 Re	v: B				Pag	ge 1 of 1
		ST ARTICLE X First A			ECKLIST totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		nments
3.085	+0.030/-0.000	3.104					
Ø0.625	+/-0.010	0.626			-		
0.050 x 45°	+/-0.010 x 45°	6053×45					
0.065	+/-0.010	.063	-				
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Measured by:	nnt	Audited b	y: 37		Prototyp	e Approval:	N/A
Date:	6/8080	Dat	e: 58/0	8/14		Date:	N/A
Rev Date				7		Revised by	Approved
Rev Date A 04.04.20	Change New Issue		. ,	·		KJ/RF	1
						KJ/JLM	

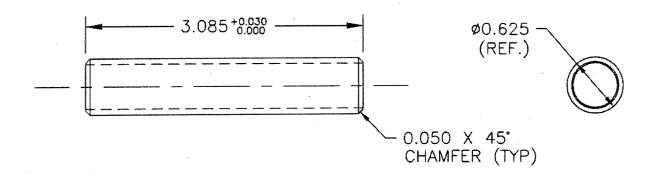
Rev	Date	Change /	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	1
В	06.11.20	Tolerance +/-0.010 x 45° was 0.48 x 45°	KJ/JLM	





DESIG	H	DRAWN BY	DART AEROSPACE BELLEVUE, WA	USA, INC.
CHECK	4.6	APPROVED	DRAWING NO.	REV. B
#	#	I KE	D2743	SHEET 1 OF 1
DATE			TITLE	SCALE
98.1	2.08		CROSS BOLT SPACER	1:1
Α		98.04.16	NEW ISSUE	
В		98.12.08	3.085 WAS 3.060	

RELEASED



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALSHOP COPY TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTIFICATION ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER